

Work Order ID 146486

Wednesday, May 18, 2016 8:57:37 AM

146486

Page 1

Item ID: D4785-115 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 6/17/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/22/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 18 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4785	B

100

0.00

100

Large Fab

Memo

2.04

Large Fab

1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9921

DAS
43
9-89

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

107

Weld per dwg A/R S.S. rod Batch: M132613 0.00

107

Large Fab

Memo

0.00

Large Fab

1- Use DT10159 for placing and tacking bushing, remove before welding.
 2- Weld bushing as per dwg D4785
 3- Grind welds flush

(4) 16.06.03

(4) 16.06.03

(4) 16.06.03

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC5- Inspect part completeness to step on W/O	0.00							
110								DAS	
QC	Memo	0.08					4/	43	JUN 03 2016
Quality Control								9-89	
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120								DAS	
QC	Memo	0.00					4/	43	JUN 03 2016
Quality Control								9-89	
130	Identify as per dwg & Stock Location: <i>WJ 04</i>	0.00							
130									
Packaging	Memo	0.04					4	16	06-03
Packaging	LOCATION: WA004								

DQA: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.40

Quality Control

MCS

JUN 03 2016

MCS JUN 03 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Picklist Print

Wednesday, May 18, 2016 8:57:36 AM

Page 1

Work Order ID: 146486

146486

Parent Item: D4785-115

D4785-115

Parent Item Name: Rib Assembly

Start Date: 6/17/2016

Required Date: 6/22/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.14 NEW ISSUE VERF:JLM
13.06.21 DWG REV.B DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured No

Each 214.0000

8

D3759-1

Bushing

**

16.06.03

Location

Loc Qty

Loc Code

WA004

214

141444

13

145615

201

Each 2.0000

4

D4306-1

Manufactured No

D4306-1

Rib

**

16.06.03

Location

Loc Qty

Loc Code

WA004

2

145233

2

B146425

4

11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

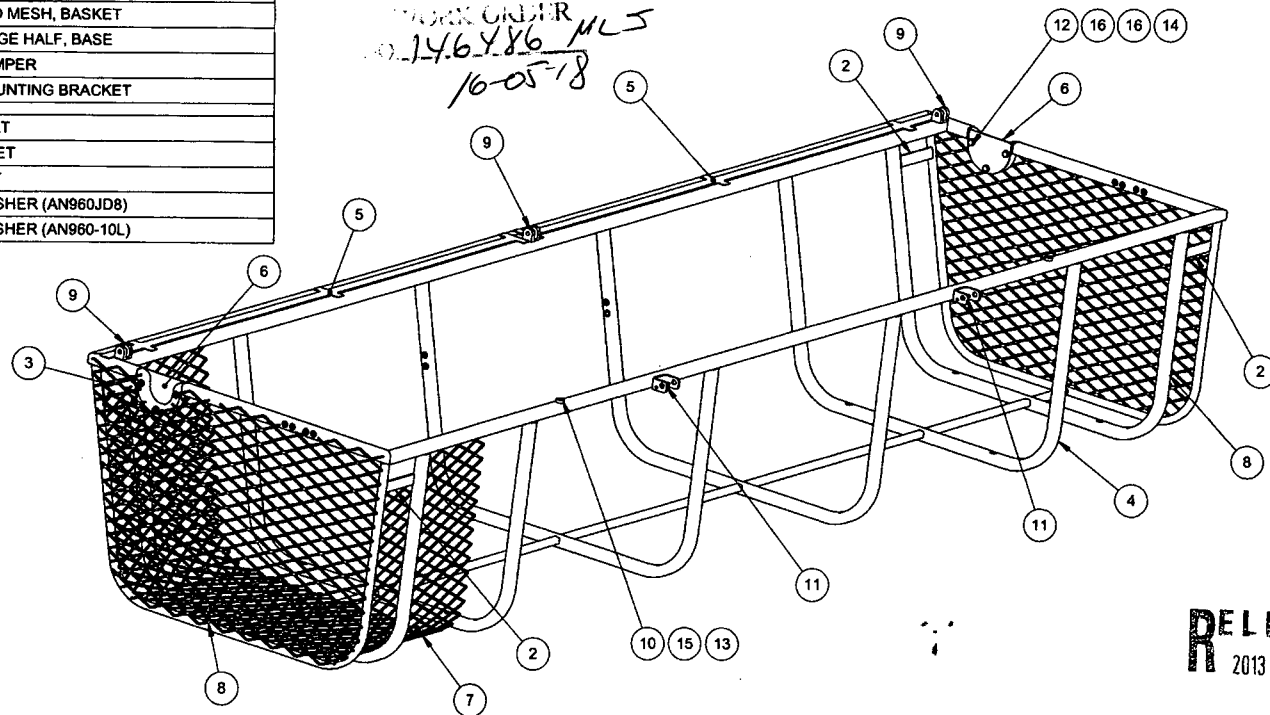
QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause				FAULT CATEGORY			
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

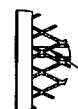
D4785-041 LONG BASKET BASE ASSY, LH/RH

B	REPLACE D3816-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	13.06.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4785		REV. B	SHEET 1 OF 7
TITLE LONG BASKET BASE ASSY		SCALE NTS	
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RELEASED
2013-06-20

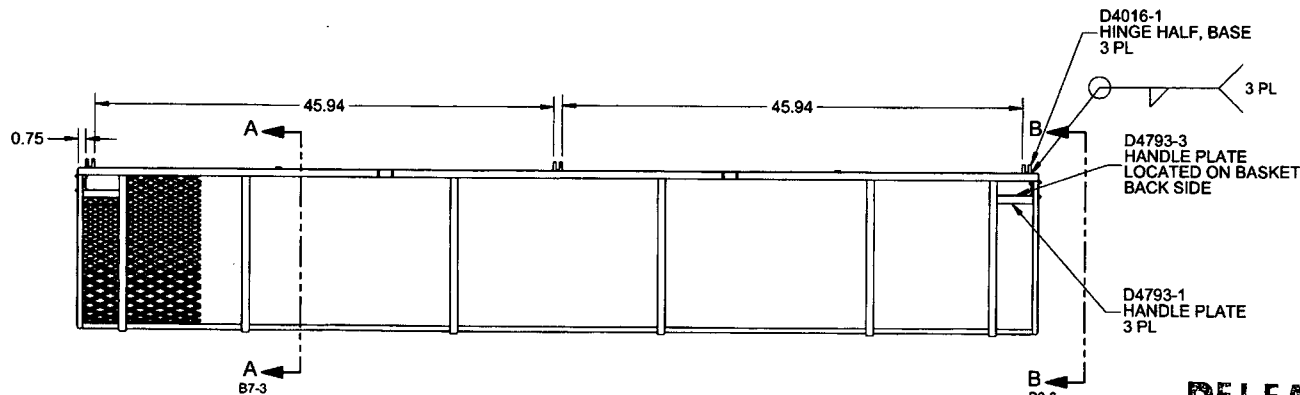
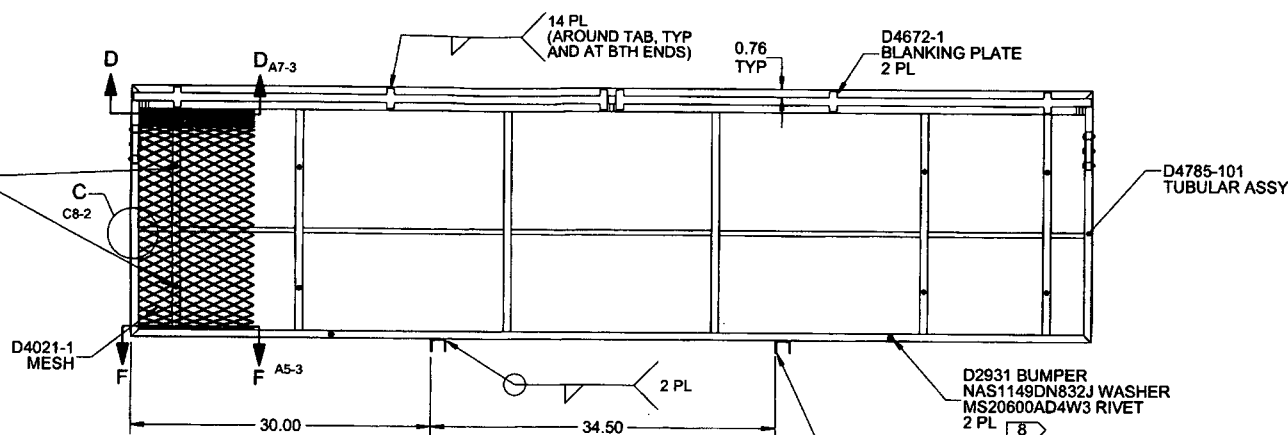
TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP

D4021-1
MESH



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

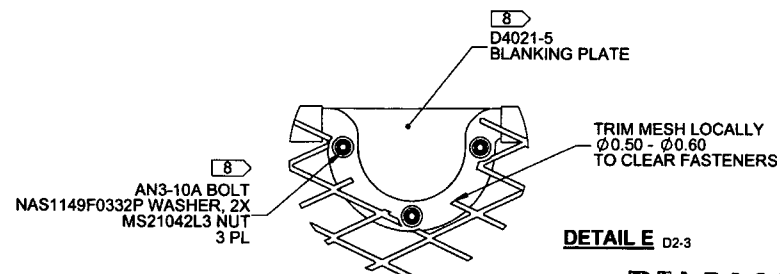
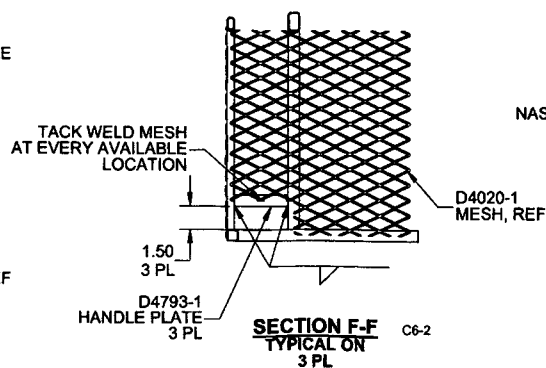
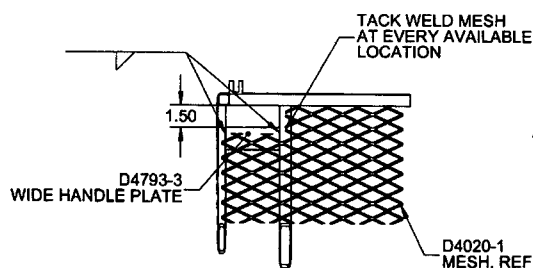
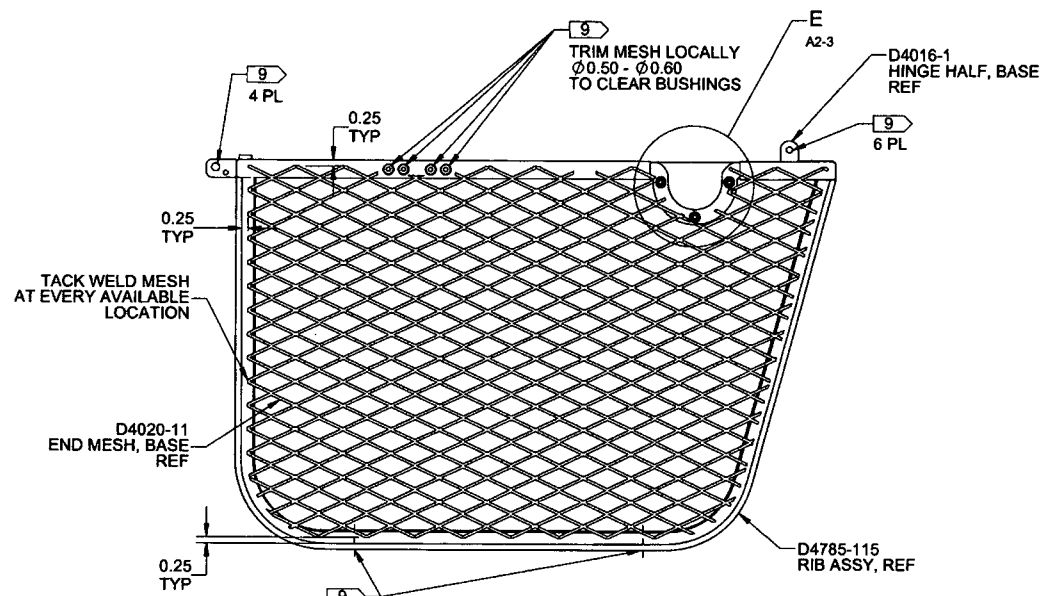
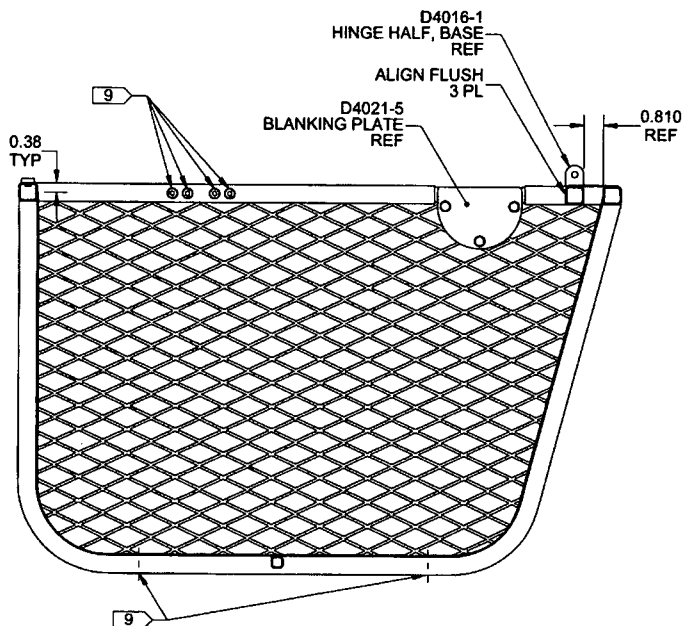
DETAIL C D7-2



D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

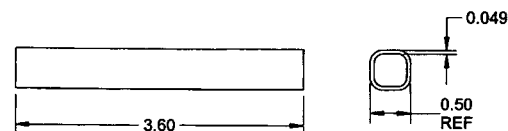
RELEASED
R 2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>IS</i>	D4785	SHEET 2 OF 7
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

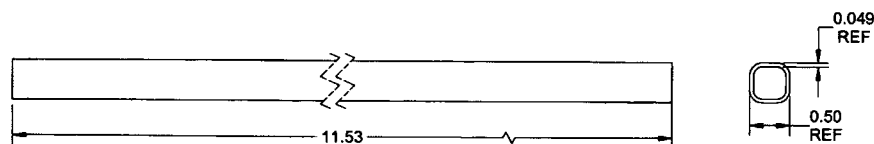


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2013-06-20

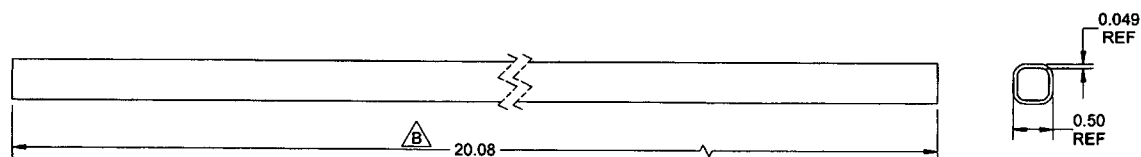
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	DS	D4785	SHEET 3 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
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D4785-1 RIB



D4785-3 RIB



D4785-5 RIB

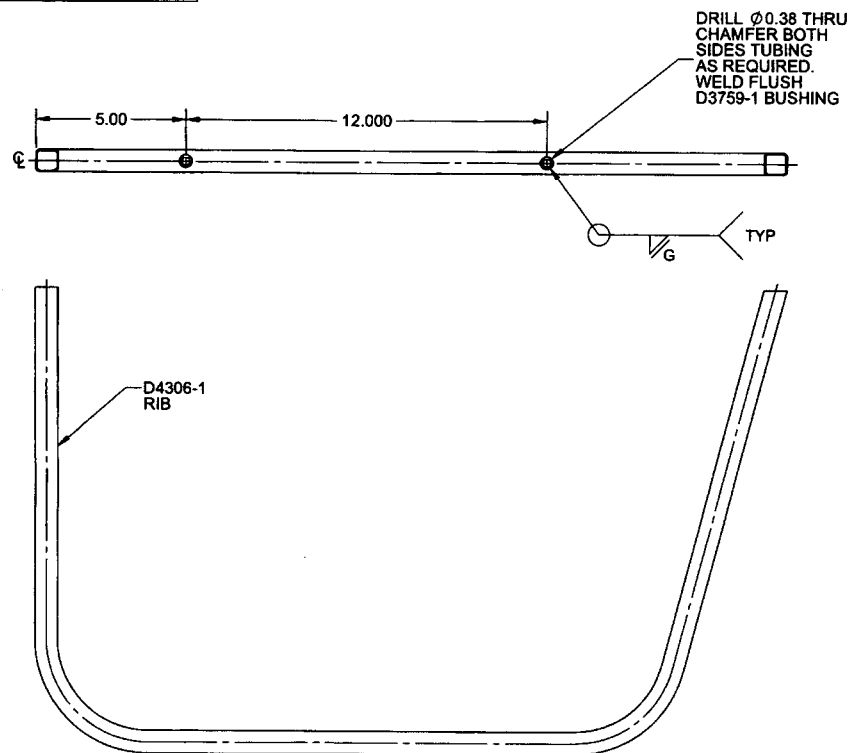
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2013-06-20
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4785	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

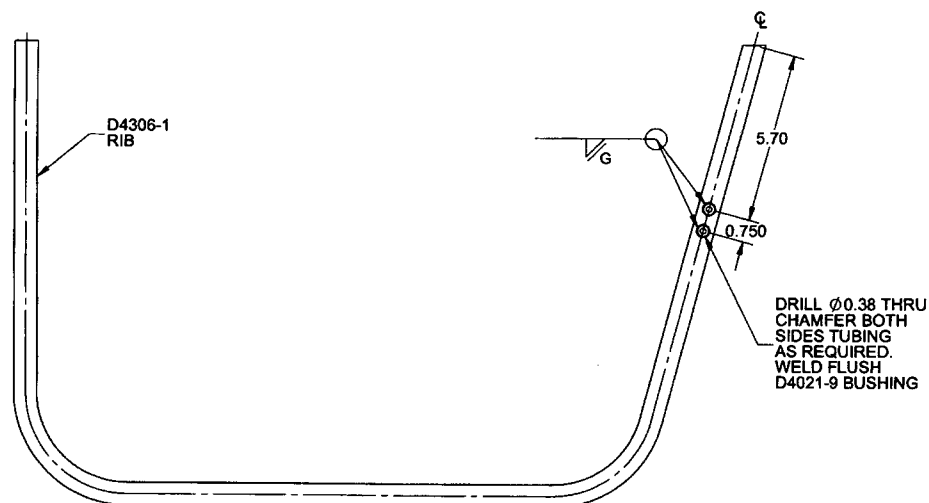
NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4785	REV. B
MFG. APPR.	DC	SHEET 6 OF 7	
APPROVED	DC	TITLE LONG BASKET BASE ASSY	SCALE NTS
DE APPR.	DC	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.06.11		

RELEASED
2013-06-20
JND

ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

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2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4785	SHEET 7 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY	NTS
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